

Date: Wednesday, 18/06/2008 1:33:06 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: AFT BASE
Job Number	: 39939		
Estimate Number	: 13037		
P.O. Number	:	Part Number	: D365113
This Issue	: 18/06/2008 S.O. No. :	Drawing Number	: D3651 REV.B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL /MED FAB	Drawing Revision	: B
Previous Run	: 37140	Material	:
Written By	:	Due Date	: 07/07/2008 Qty: 2 Um: Each
Checked & Approved By	: <u>JUL 08 6.18</u>		
Comment	Est Rev:A New Issue 07-09-27 DD verified by: EC Est Rev:B ECN 1113P 08-01-22 DD Est Rev:C ecn1162 08-04-02 DD verified by: EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S26GA	304/316 0.018 SHEET
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Comment: Qty.: 0.7140 sf(s)/Unit Total : 1.4280 sf(s)
 304/316 SS sheet 26 ga (0.018" thick)
 Batch: 108 415 IB 8-6-26

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET
 1-Cut as per Dwg D3651
 Dwg Rev: B
 Prog Rev: B

IB 8-6-26

(3)

2-Deburr if necessary

IB 8-6-26

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

IB 8-6-26

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

18-06-27 (3)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1
 Identify and stock
 Location: GA

SB 08/07/21

(3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 18/06/2008 1:33:06 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT BASE

Job Number: 39939

Part Number: D365113

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



08/07/2008

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



u 08.07.21

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 39939
Description: Outside Doubler		Part Number: D3651-13
Inspection Dwg: D3651	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

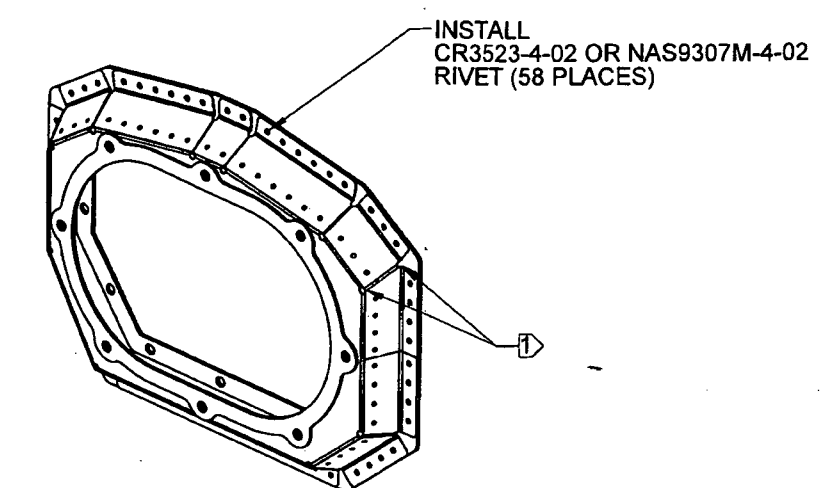
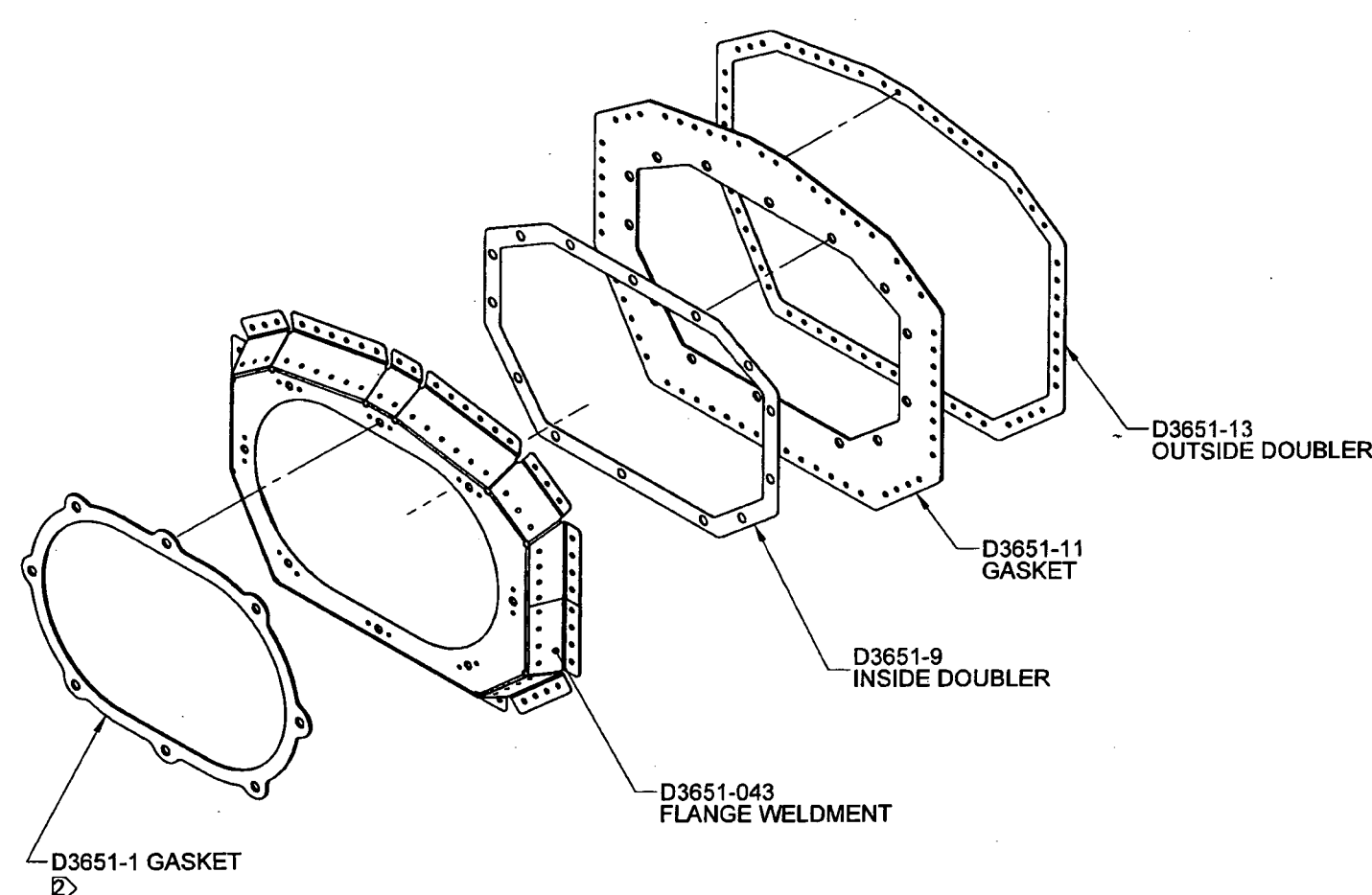
☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.129	+0.005/-0.001	.131	X		✓	
0.260	+/-0.010	.260	*		✓	
2.471	+/-0.010	2.475	*		✓	
9.791	+/-0.010	9.791	*		T	
0.634	+/-0.010	.631	*		✓	
2.564	+/-0.010	2.566	*		✓	
0.52	+/-0.030	.522	*		✓	
0.600	+/-0.010	.600	*		✓	
0.500	+/-0.010	.504	*		✓	
7.969	+/-0.010	7.970	*		✓	
2.348	+/-0.010	2.348	*		✓	
0.480	+/-0.010	.481	*		✓	
5.571	+/-0.010	5.574	*		✓	
0.696	+/-0.010	.697	*		✓	
7.049	+/-0.010	7.051	*		✓	
3.564	+/-0.010	3.564	*		✓	
0.694	+/-0.010	.694	*		✓	
1.779	+/-0.010	1.777	*		✓	
8.74	+/-0.030	8.74	*		T	

Measured by: BA	Audited by: [Signature]	Prototype Approval:	N/A
Date: 8-6-26	Date: 08.06.27	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.04.17	New Issue	KJ/DD	[Signature]

8 7 6 5 4 3 2 1



PART LIST

QTY -041	PART NUMBER	DESCRIPTION
X	D3651-041	AFT BASE ASSEMBLY
1	D3651-043	FLANGE WELDMENT
1	D3651-1	GASKET
1	D3651-9	INSIDE DOUBLER
1	D3651-11	GASKET
1	D3651-13	OUTSIDE DOUBLER
58	CR3523-4-02 or NAS9307M-4-02	RIVET

D3651-041 AFT BASE ASSEMBLY

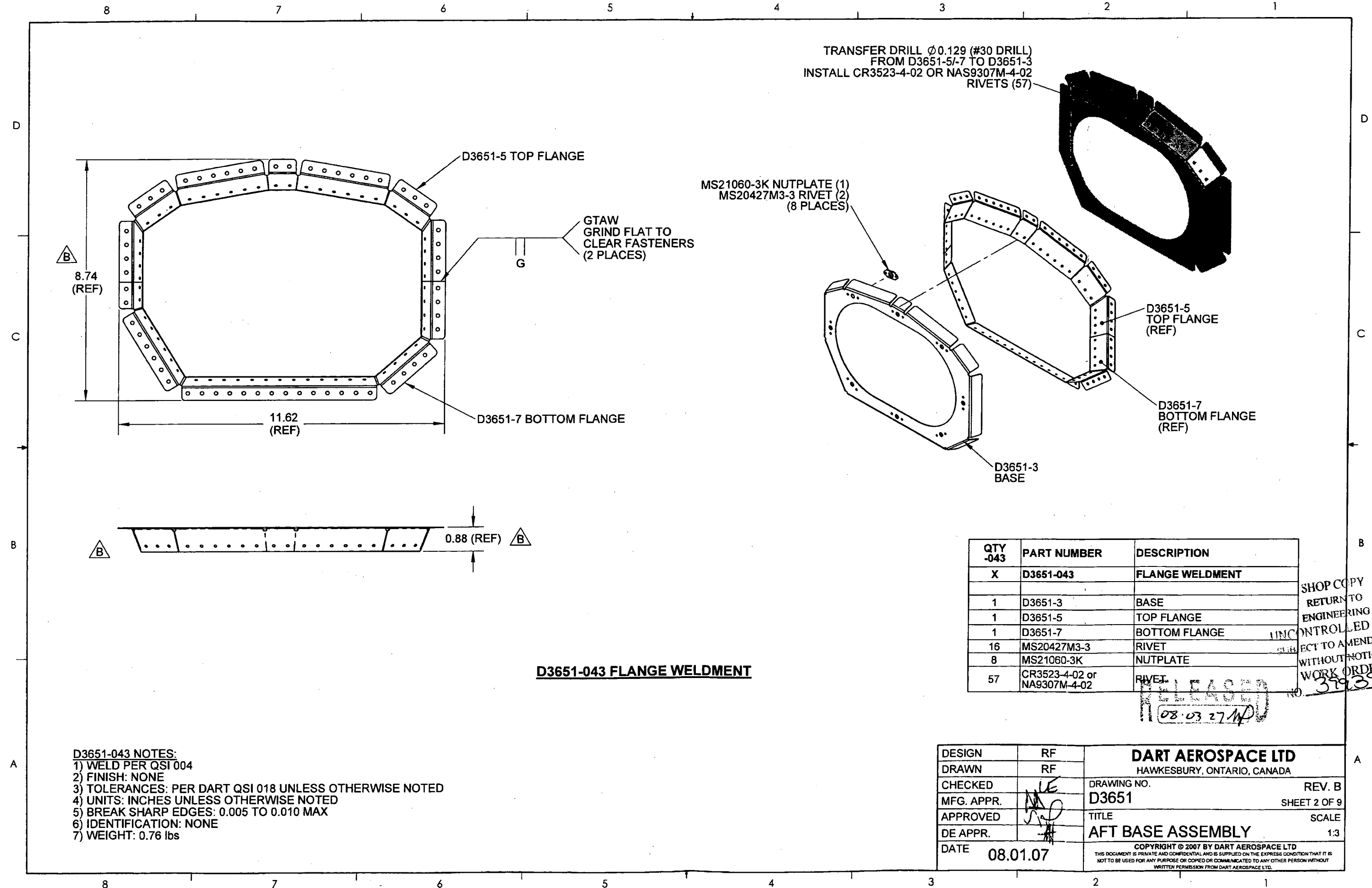
D3651-041 NOTES:

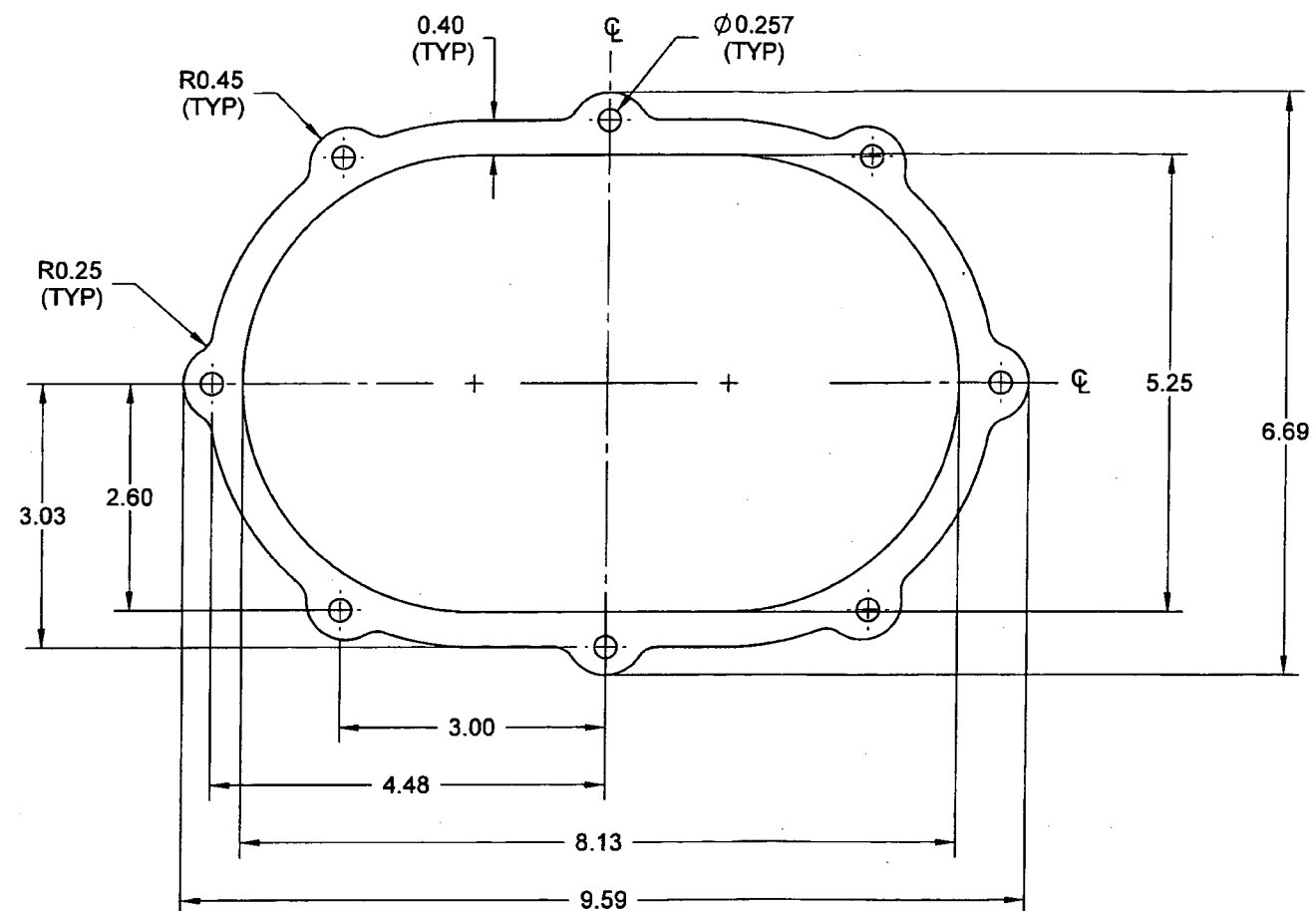
- 1) SEAL ALL MATING SURFACES AND GAPS USING PROSEAL 700 FIRE WALL SEALANT
- 2) INSTALL D3651-1 USING 3M HIGH PERFORMANCE CONTACT ADHESIVE 1357
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.6 lbs

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08-03-27

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B	SHEET 1: GENERAL UPDATE SHEET 2: 8.74 WAS 8.50; 0.88 WAS 0.98; REMOVED ANGLE SHEETS 4, 5, 6, 8 & 9: GENERAL DIMENSIONAL UPDATE SHEET 7: 5.514 WAS 5.504	RF	08.01.07
A	NEW ISSUE	RF	07.11.07
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D3651	SHEET 1 OF 9
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DE APPR.	RF	AFT BASE ASSEMBLY	1:4
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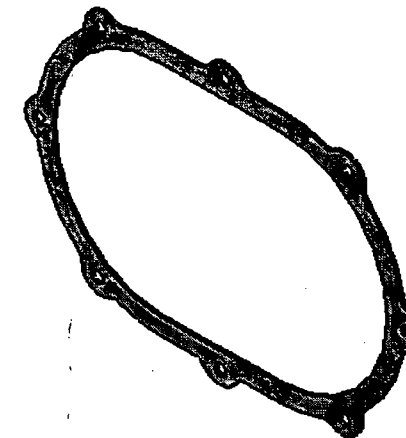




D3651-1 GASKET

NOTES:

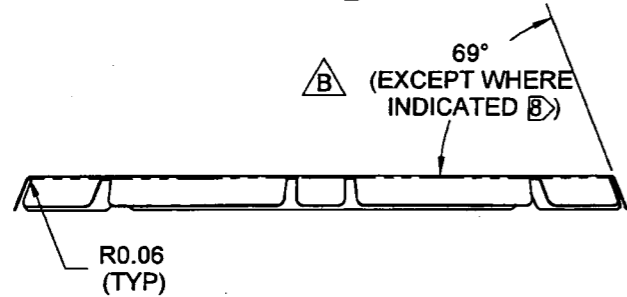
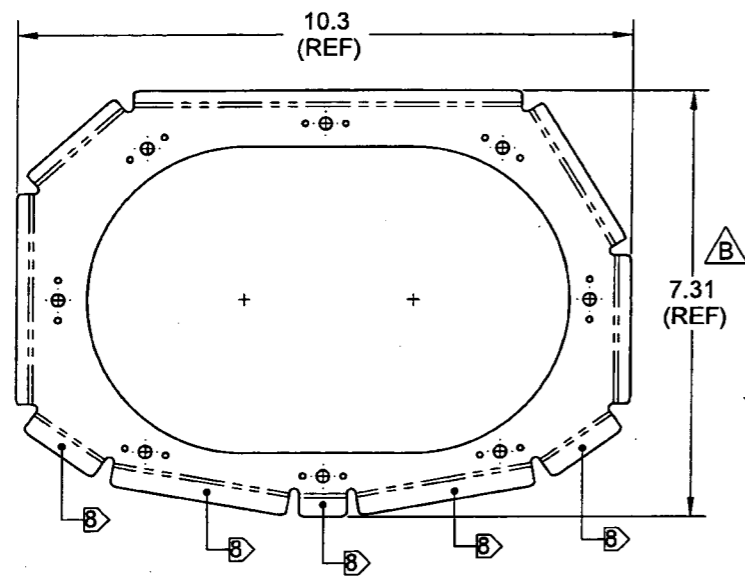
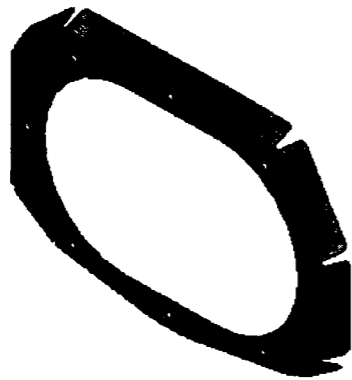
- 1) MATERIAL: THERMO-CHEM P/N G-89, (REF. 0.060 THICK)
POSSIBLE SUPPLIER: A.R. THOMSON GROUP
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) PART IS SYMMETRIC ABOUT ϕ
- 8) WEIGHT: 0.09 lbs



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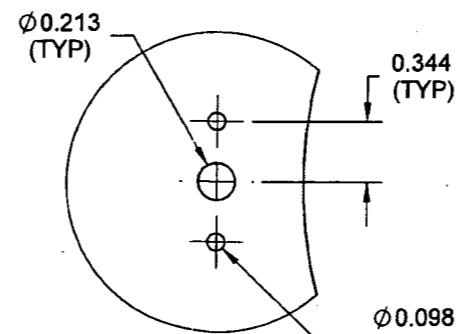
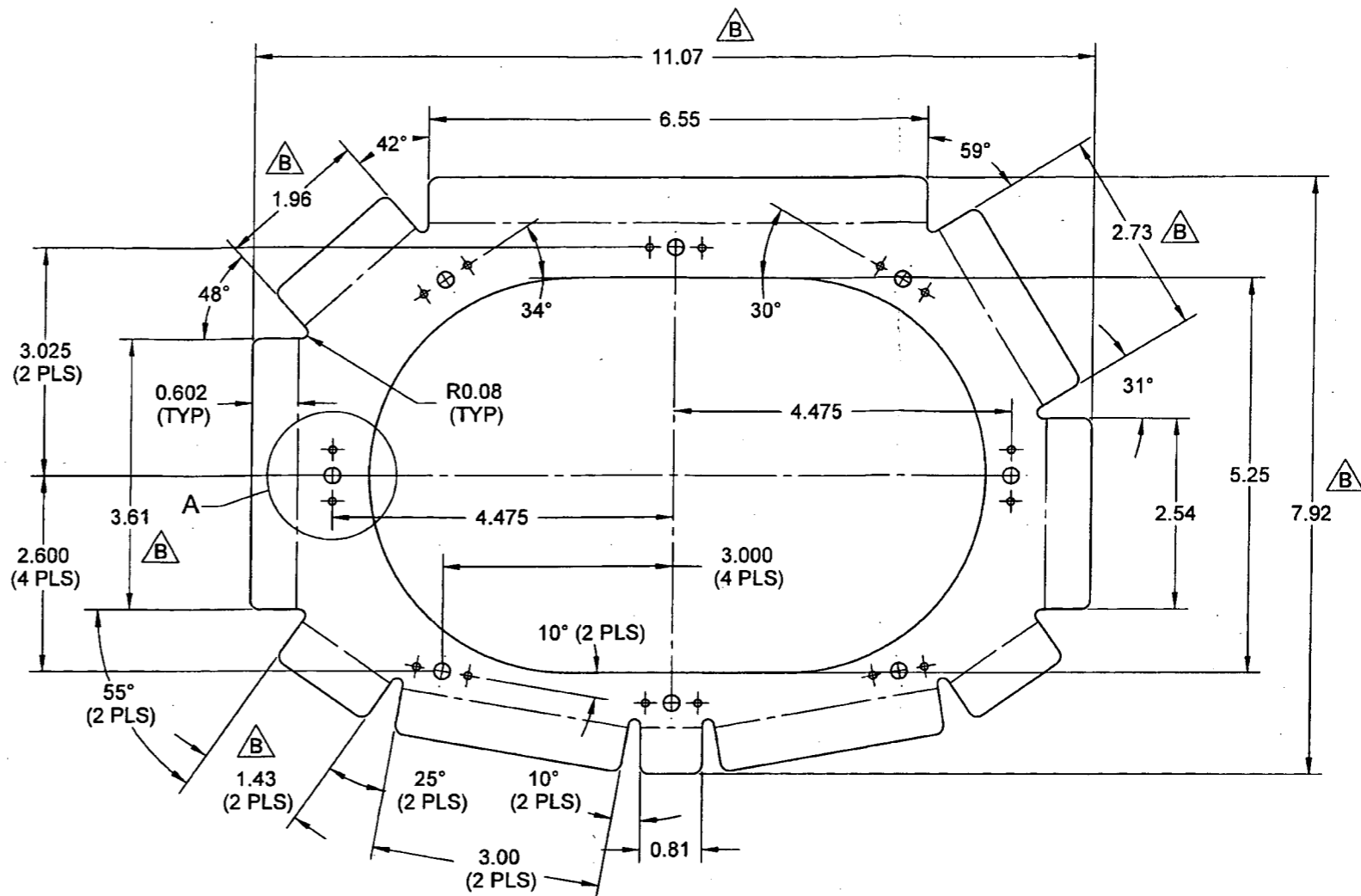
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DRAWN	RF		
CHECKED	KE	DRAWING NO. D3651	REV. B
MFG. APPR.	KE	SHEET 3 OF 9	
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D3651-3 BASE
(MAKE FROM D3651-3F FLAT PATTERN)

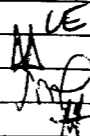
NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 (26 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.27 lbs
- 8) BEND TO 55° WHERE INDICATED

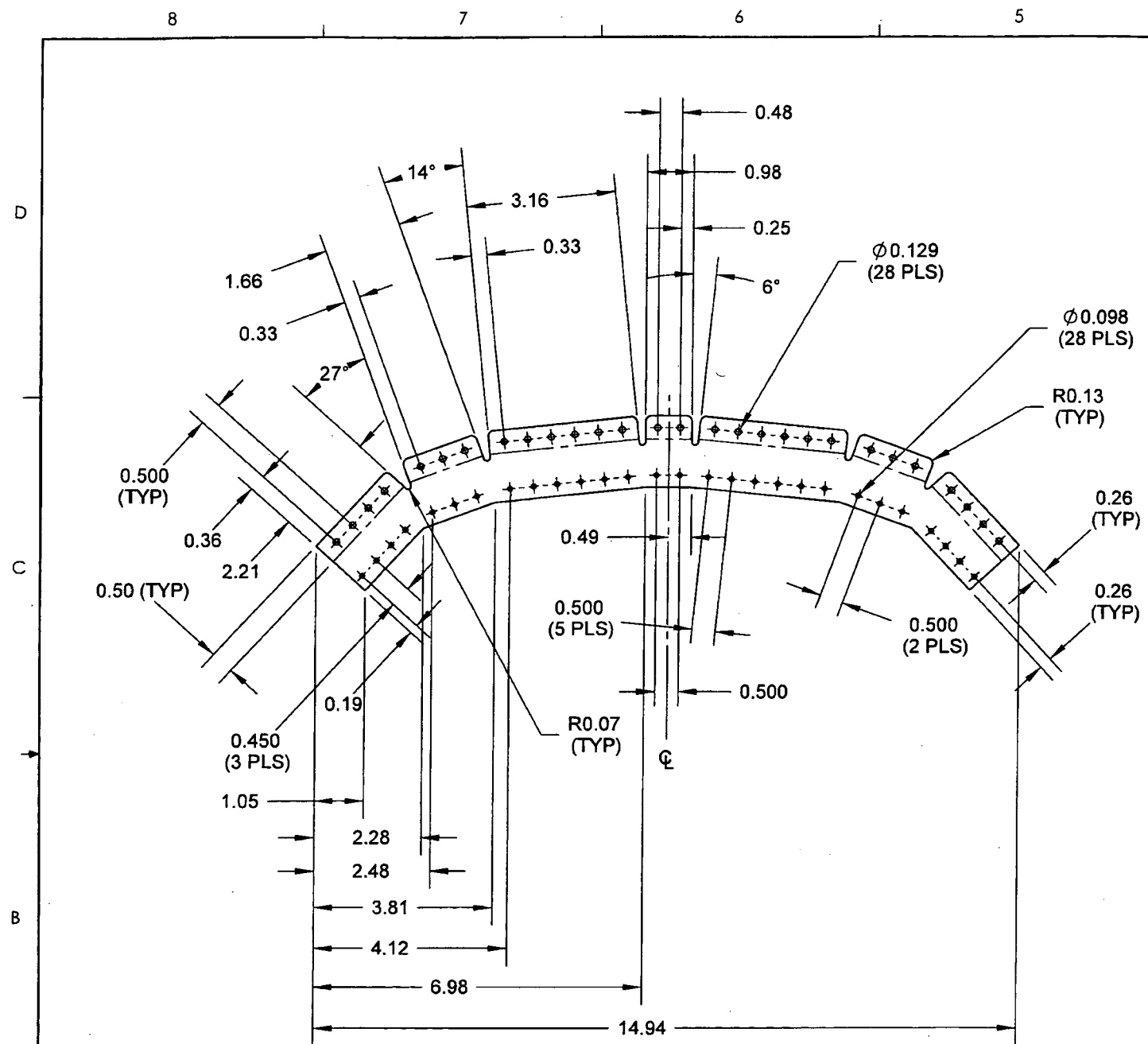


DETAIL A

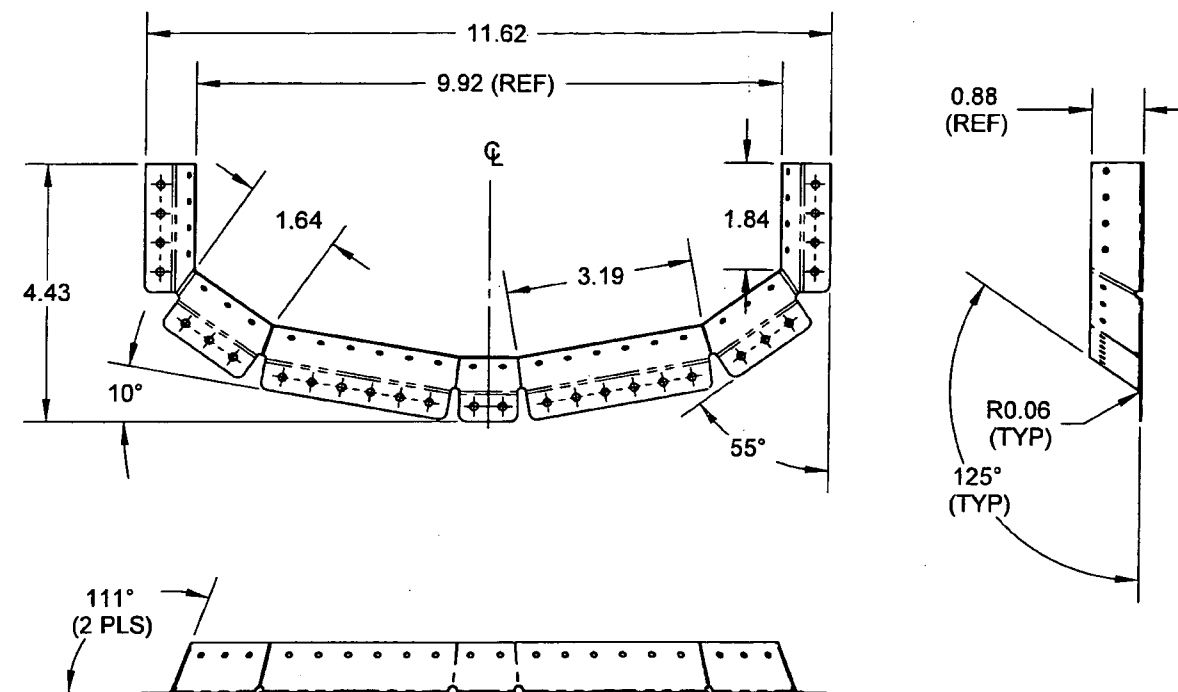
D3651-3F FLAT PATTERN

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D3651-5F FLAT PATTERN 







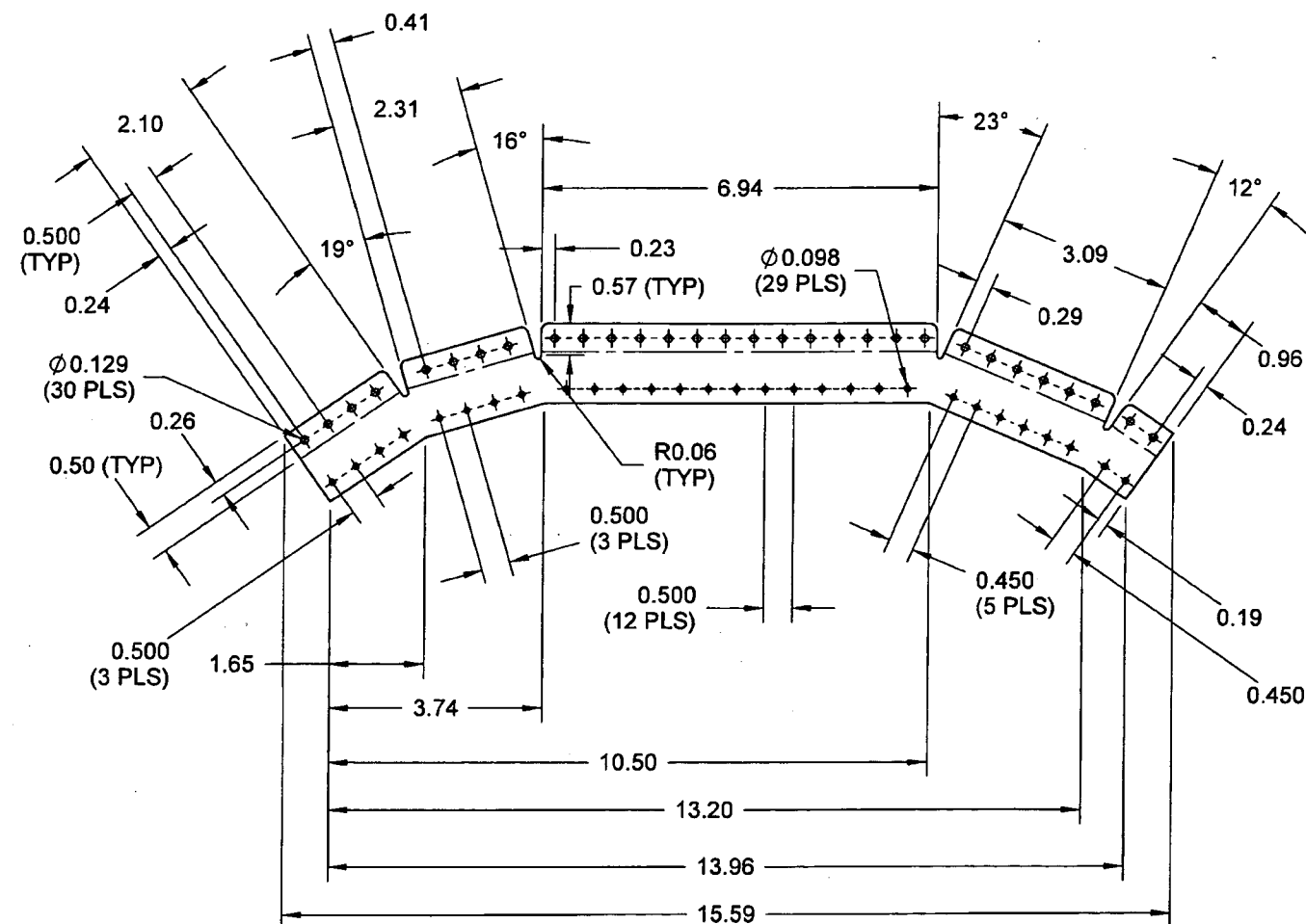
D3651-5 TOP FLANGE BEND DETAIL
(MAKE FROM D3651-5F FLAT PATTERN)

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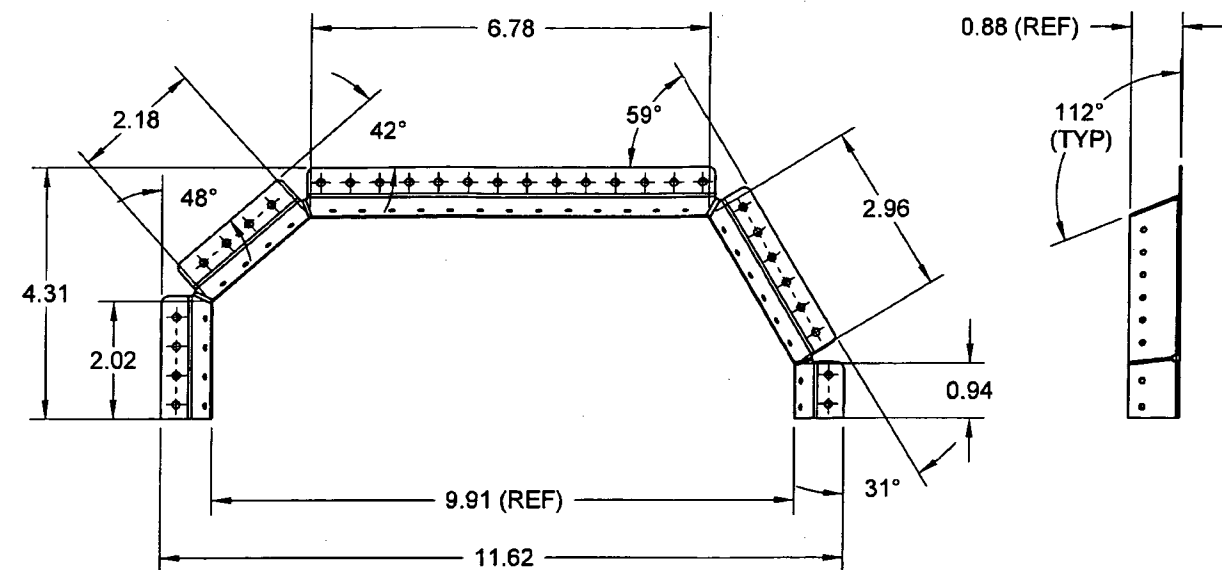
NOTES:

- NOTES:
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 (26 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.02 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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D3651-7F FLAT PATTERN B



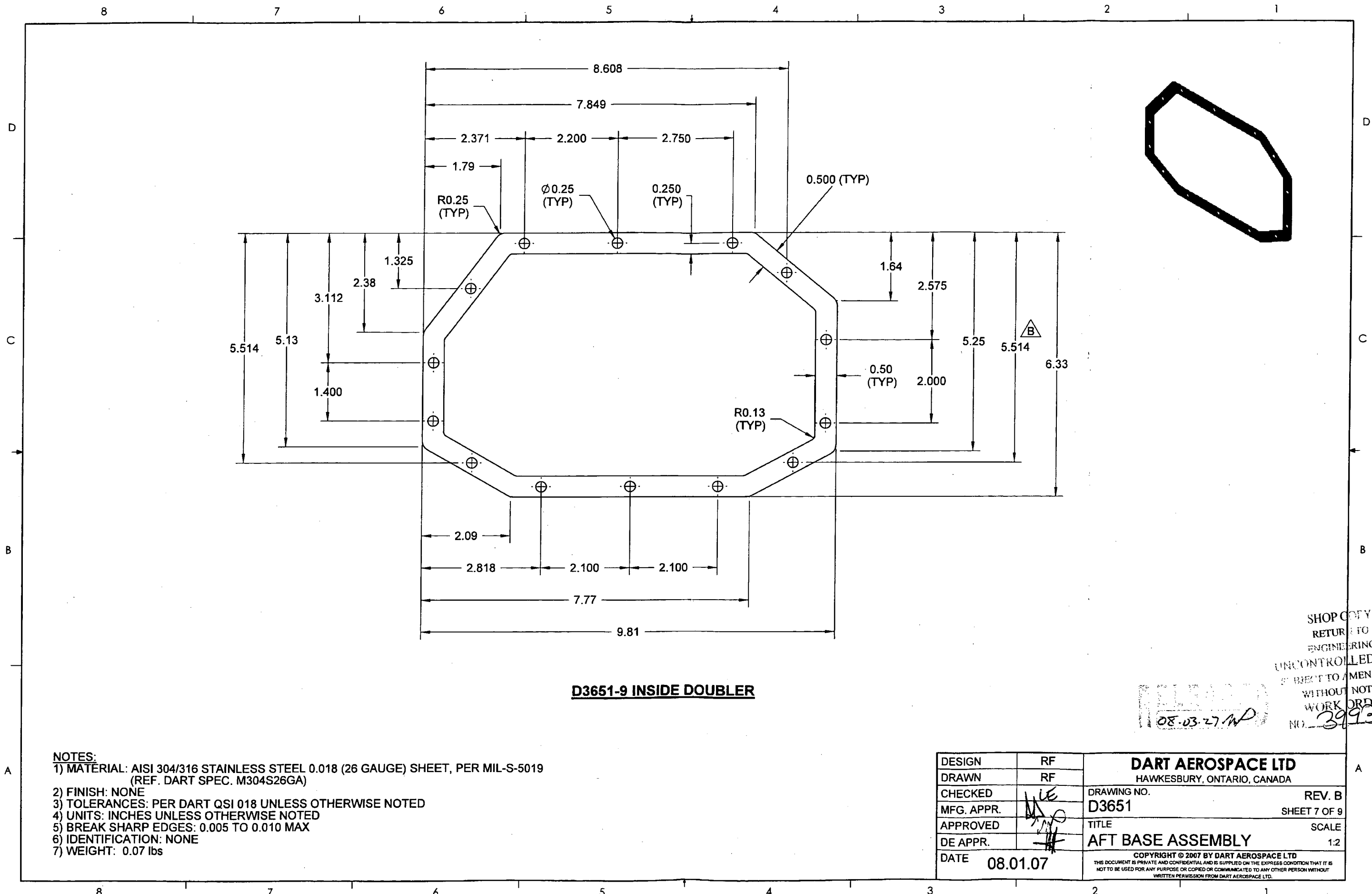
D3651-7 BOTTOM FLANGE BEND DETAIL B
(MAKE FROM D3651-7F FLAT PATTERN)

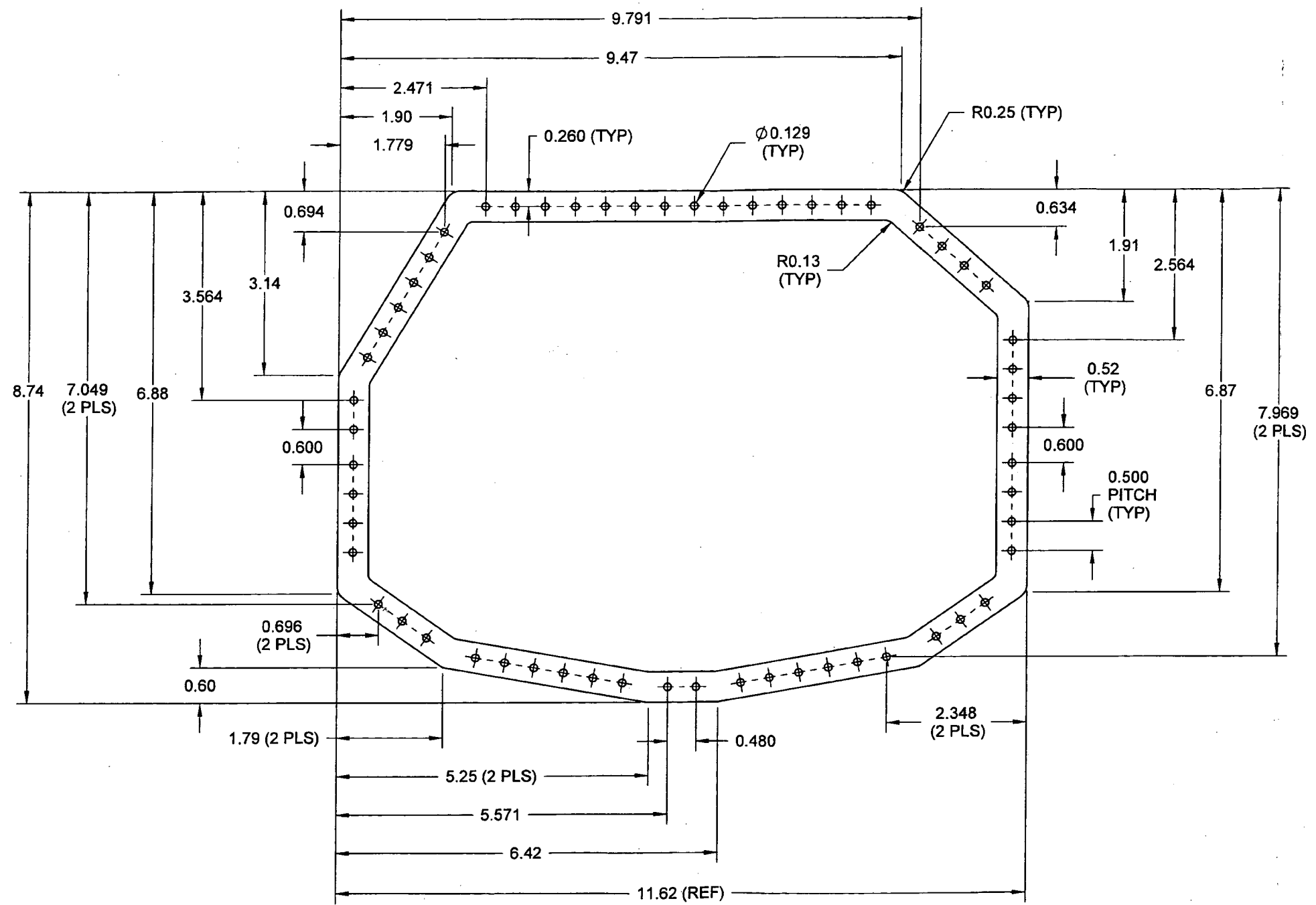
NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 (26 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.02 lbs

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D3651-13 OUTSIDE DOUBLER B

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08-03-27/MP

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 (26 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.10 lbs

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